

Work Order ID 53049

October 22, 2009 11:27:53 AM



Page 1

Item ID:	D3883-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Outboard RH					
Start Date:	21/10/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>BS</u>	Date:	<u>09-10-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3883	B

100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1		0.00							
HAAS CNC vertical machine #1									

Memo

Program Batch No. 53049

Double check by: _____

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

SL 09/11/01

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control									

Memo

SL 09/11/01 4

Picklist Print

October 22, 2009 11:28:00 AM

Page 1

Work Order ID: 53049



Parent Item: D3883-2RevB



Parent Item Name: Saddle, Outboard RH

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-015RevB		Manufactured	No			100	Each	20.0000	4.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MACHINING

51834

20

20

4 JK 09/11/09

DART AEROSPACE LTD		Work Order: 53049
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883 Rev. B		Page 1 of 1

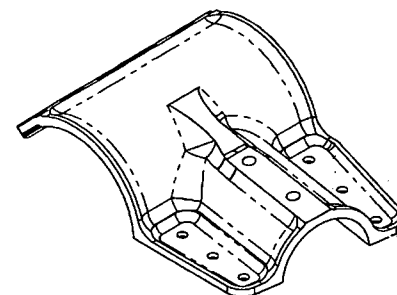
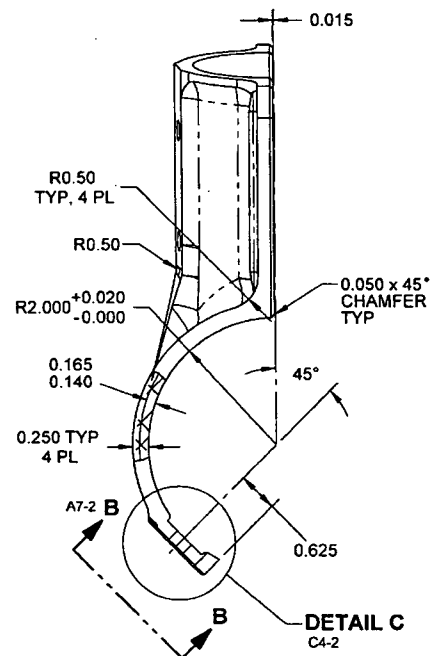
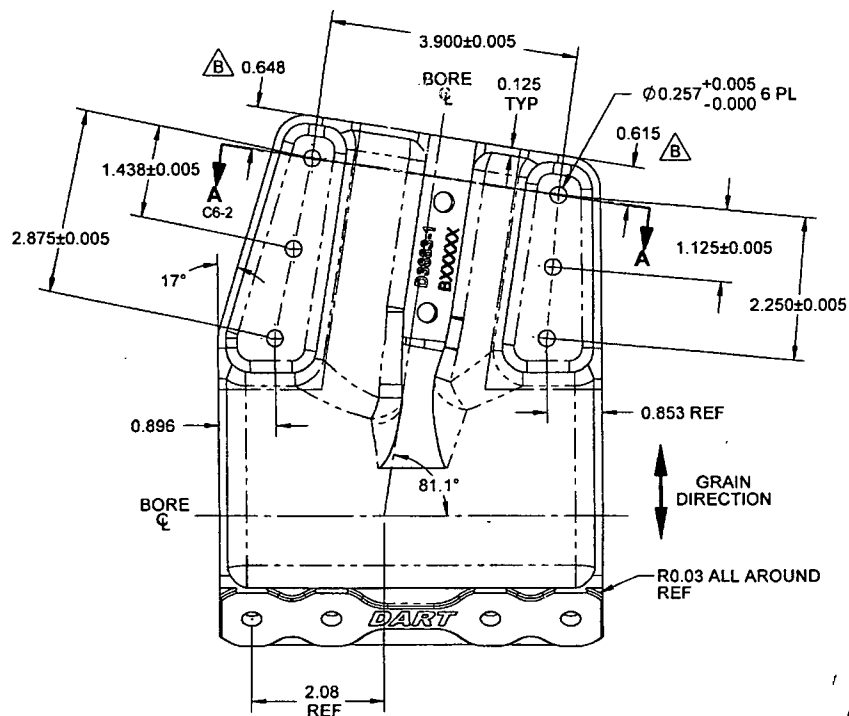
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.648	.648	.647	.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.615	.614	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.001	2.000	2.002	2.003		
J	0.140	0.165		.150	.150	.149	.149		
K	0.240	0.260		.250	.249	.250	.249		
L	0.115	0.135		.125	.124	.124	.125		
M	0.140	0.165		.153	.153	.153	.153		
N	0.720	0.780		.770	.770	.770	.770		
O	0.240	0.260		.249	.249	.247	.247		
P	0.110	0.140		.130	.130	.136	.130		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.868	2.868	2.868	2.868		
S	0.316	0.321		.320	.320	.320	.320		
T	0.990	1.010		1.005	1.005	1.005	1.006		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	5.999	5.999	5.999		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.498	.499	.498	.498		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.315	.315	.315	.315		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.218	.218	.218		
AE	1.265	1.285		1.268	1.268	1.269	1.270		
AF									
Accept/Reject									

Measured by:	JL
Date:	09/11/01

Audited by:	DT
Date:	09/11/02

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	



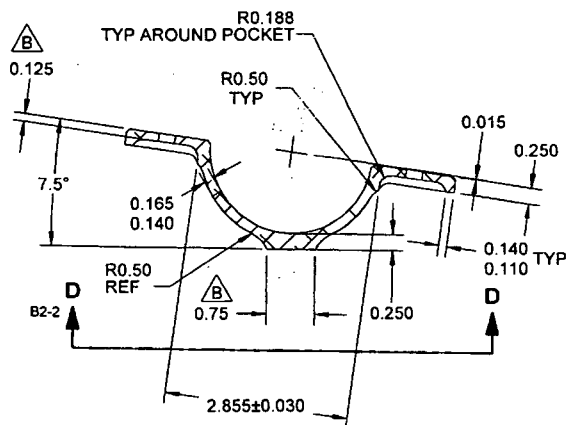
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53049
09-06-30

RELEASED
01/15/15

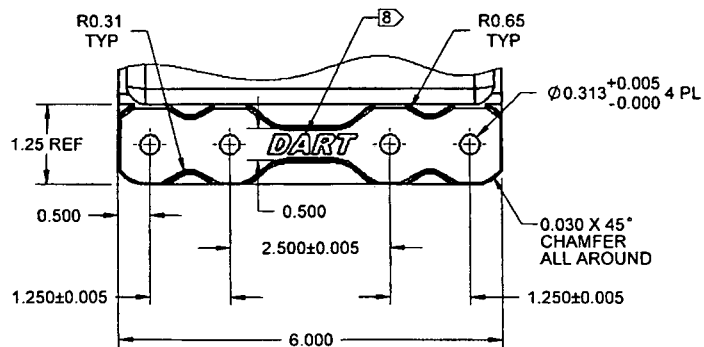
D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

- NOTES:
1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 1.00 lbs
8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

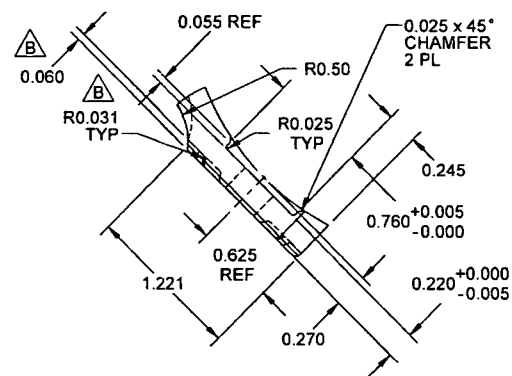
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN 65-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3883	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



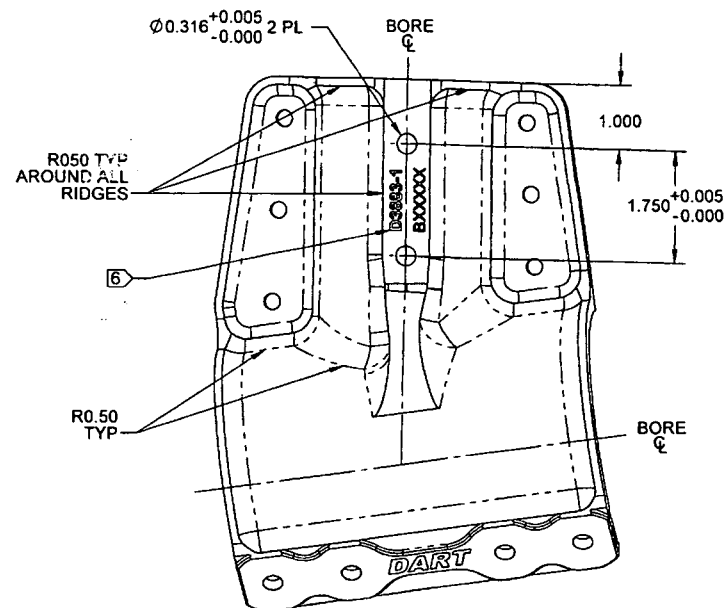
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3883	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
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